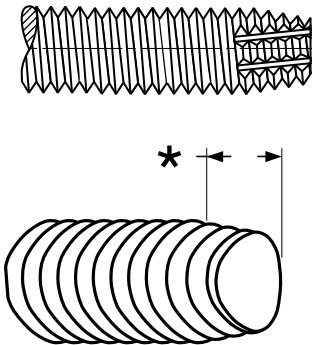
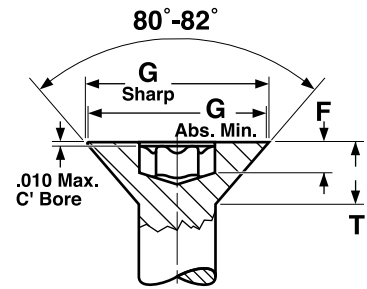
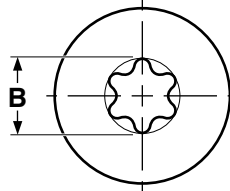


THREADS AND POINTS FOR TYPE-F THREAD CUTTING SCREWS														ASME B18.6.4-1998
Nominal Size or Basic Screw Diameter	Threads Per Inch	D		P	S				L				Minimum Torsional Strength, lb.-in. (STEEL SCREWS ONLY)	
		Major Diameter		Point Diameter	Point Taper Length				Determinant Length for Point Taper		Minimum Practical Screw Lengths			
		Max	Min	Ref	Max	Min	Max	Min	90° Heads	Csk Heads	90° Heads	Csk Heads		
2	.0860	56	.0860	.0813	.068	.062	.045	.080	.062	5/32	3/16	5/32	3/16	5
4	.1120	40	.1120	.1061	.087	.088	.062	.112	.088	7/32	1/4	3/16	1/4	13
5	.1250	40	.1250	.1191	.100	.088	.062	.112	.088	7/32	9/32	3/16	1/4	18
6	.1380	32	.1380	.1312	.107	.109	.078	.141	.109	1/4	5/16	1/4	5/16	23
8	.1640	32	.1640	.1571	.132	.109	.078	.141	.109	1/4	11/32	1/4	5/16	42
10	.1900	24	.1900	.1818	.148	.146	.104	.188	.146	11/32	7/16	5/16	13/32	56
10	.1900	32	.1900	.1831	.158	.109	.078	.141	.109	1/4	11/32	1/4	5/16	74
12	.2160	24	.2160	.2078	.174	.146	.104	.188	.146	11/32	7/16	5/16	13/32	93
1/4	.2500	20	.2500	.2408	.200	.175	.125	.225	.175	13/32	17/32	3/8	1/2	140
5/16	.3125	18	.3125	.3026	.257	.194	.139	.250	.194	15/32	19/32	7/16	9/16	306
3/8	.3750	16	.3750	.3643	.312	.219	.156	.281	.219	1/2	11/16	15/32	5/8	560
1/2	.5000	13	.5000	.4876	.423	.269	.192	.346	.269	5/8	25/32	19/32	3/4	1075
Tolerance on Length		Up to 3/4 in., incl.: -0.03				Over 3/4 to 1-1/2 in., incl.: -0.05				Over 1-1/2 in.: -0.06				

<b>Description</b>	A thread cutting screw with machine screw thread pitch, blunt point, tapered entering threads and multiple cutting edges.
<b>Applications/ Advantages</b>	Steel thread-cutters are used in heavy gauge sheet metal, aluminum, zinc and lead die castings, cast iron, brass and plastic. Stainless screws offer additional resistance to corrosion, 18-8 moreso than 410. When using any thread-cutting screw, the material in which the threads are cut should have a lower hardness by at least 10 to 20 Rockwell hardness points.
<b>Material</b>	<b>Steel:</b> AISI 1016 - 1024 or equivalent steel. <b>Stainless:</b> 410 martensitic stainless steel or 18-8 stainless steel.
<b>Heat Treatment</b>	<b>410 Stainless:</b> Screws shall be annealed by heating to 1850-1950°F, held at least for 1/2 hour and rapid air- or oil-quenched then reheating to 525°F minimum for at least 1 hour and air cooled to provide the required tensile, yield and hardness properties.
<b>Surface Hardness</b>	<b>Steel:</b> Rockwell C45 minimum
<b>Case Depth (steel)</b>	No. 4 thru 6 diameter: .002 - .007 No. 8 thru 12 diameter: .004 - .009 1/4" diameter & larger: .005 - .011
<b>Core Hardness</b>	<b>Steel (after tempering):</b> Rockwell C28 - 38 <b>410 Stainless:</b> Rockwell C38 - 42; <b>18-8 Stainless:</b> Rockwell B90 - C20
<b>Plating</b>	See Appendix-A for information on plating of steel thread cutting screws.



\*2-3 Pitch Lead Length



TORX® DRIVE FLAT HEADS (FLOORBOARD)									Camcar
Nominal Size or Basic Screw Diameter		G		T	B	F		Drive Size	
		Head Diameter		Head Height	Recess Diameter	Gauge Penetration			
		Max Sharp	Abs. Min	Ref	Ref	Max	Min		
6 (U-Cut)	.138	.279	.244	.059	.111	.028	.024	T10	
8	.164	.332	.292	.100	.132	.054	.045	T15	
10	.190	.385	.340	.116	.155	.064	.053	T20	
12	.216	.438	.389	.132	.178	.073	.061	T25	
1/4	.250	.520	.452	.160	.221	.104	.085	T30	
5/16	.312	.648	.568	.199	.266	.109	.090	T40	
3/8	.375	.762	.685	.230	.266	.109	.090	T40	
1/2**	.500	.875	.775	.223	.352	.144	.120	T50	

<b>Description</b>	A countersunk, torx drive thread cutting screw with machine screw thread pitch, blunt point, tapered entering threads, and multiple cutting edges. Larger diameter sizes may also be supplied as a thread rolling screw rather than thread cutting. Floorboard screws are, by definition, available in much longer sizes than standard type-F screws.
<b>Applications/ Advantages</b>	Floorboard screws are specifically designed for installing wood floors into truck trailers.
<b>Material</b>	AISI 1016 - 1024 or equivalent steel
<b>Heat Treatment</b>	Screws shall be quenched in liquid and then tempered by reheating to 650°F minimum.
<b>Surface Hardness</b>	Rockwell C45 minimum
<b>Case Depth</b>	<i>No. 8 thru 12 diameter:</i> .004 - .009 <i>1/4" diameter &amp; larger:</i> .005 - .011
<b>Core Hardness (after tempering)</b>	Rockwell C28 - 38
<b>Thread Dimensions</b>	<i>#8 thru 3/8" diameters:</i> Same as those for Type-F thread cutting screws. <i>1/2" diameter:</i> Same as those for a thread rolling screw.
<b>Plating</b>	See Appendix-A for information on the plating of floorboard screws.